Work Order ID 58074 April 22, 2010 2:23:49 PM										Page 1
Item ID: D4049-1 Revision ID: Item Name: Lug	1.0 Am	Accept					Setup	Start Stop		
Start Date: 4/22/10 Start Qty: 2.00 Required Date: 4/30/10 Req'd Qty: 2.00			Cust Item II Customer:) :						
Approvals: Process Plan: QC:	Date: 10-4-2	? Tooling: _ SPC (Y/N):	Date Date Date Date Date Date Date Date				Run	Start Stop		
Sequence ID/ Operation Work Center ID Description	<u>.</u>	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr Revision Nbr	3 1 1								,	
D4049 Bandsaw Bandsaw Jeaspa Bandsaw CUT BLAN	K 2.200" LONG	0.00 Ø·A	10/04/29		······································	4	Ø	<u>/</u>		
HAAS I HAAS CNC vertical machine #1 Memo mill as per of FOLIO RE DWG REV	dwg and FOLIO FA900	0.00 0.00	10.5.3			4			· · · · · · · · · · · · · · · · · · ·	

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Da	rt	Ae	ros	pa	ce	LI	d
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W/O:			WC	RK ORDER CHANG	ES				<u> </u>
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	.:	Date: _	
Resolution: Disposition: QA: N/C Closed:						Date: _	w		
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC Corrective Action			n B	Verifica	ation	Approvai	Approval
	OIL!	Section A	Initial Chief Eng	Action Description Chief Eng			Section C		QC Inspector
		·							
							4 .		

April 22, 2010 2:23:50 PM

Item ID: **Revision ID:** D4049-1

Item Name: Lug

Start Date: 4/22/10

Required Date: 4/30/10

Start Oty: 2.00 **Reg'd Otv:** 2.00



Accept



Setup Start



Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling: SPC (Y/N):

Date:

Draw

Rev.

Date:

Run Start

Reject

Qty

Stop

Reject

Number



Insp.

Stamp

Sequence ID/ Work Center ID

120

Quality Control

130

Quality Control

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Memo

QC8- Inspect parts - second check

Memo

Set Up/ Run Hours

0.00

Draw

Number

Plan

Code

Oty

Accept

Identify as per dwg & Stock Location: W

0.00

B 10-5-3

140

Packaging

Packaging

Memo

									_
W/O:			WC	ORK ORDER CHANG	ES				•
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ A	\:	Date:	
		solution:							
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC	fm:sint	on B	ation Approval		Approval		
	Section A	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector
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Work Order ID 58074



Page 3

April 22, 2010 2:23:50 PM

Item	ID.	
Hem	11/	

D4049-1

Accept



Setup Start



Stop

Revision ID:

Item Name: Lug

4/22/10 **Start Date:**

Required Date: 4/30/10

Operation

Description

Start Oty: 2.00

Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop

Sequence ID/

Work Center ID

150

OC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** Draw Number Draw Rev.

Plan Accept Code Qty

Reject Qty

Reject Insp. Stamp Number

Memo

0.00

0.00

Ouality Control

Date:

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W/O:			W	ORK ORDER CHAN	GES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	R	esolution:	Disposition	on:	QA:	N/C Clo	sed:		Date:	
NCR:			WORK ORE	ER NON-CONFORM	IANCE	(NCR)			
DATE	STEP	Description of NC Corrective Action			Ve			Verification Approval		Approval
DAIL	SILF	Section A	Initial Chief Eng			Sign & Section C			Chief Eng	QC Inspector
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Picklist Print

April 22, 2010 2:23:47 PM

Work Order ID: 58074

Parent Item: D4049-1

Parent Item Name: Lug

IPP REV: A NEW ISSUE 10-01-19 JLM VERIFIED BY:EC

as per dwg revA DD 10.02.18 verified by:EC

IPP Rev:B

Start Date: 4/22/10

Required Date: 4/30/10

Start Qty: 2.00 Required Qty: 2.00

Qty

Issued

Component Item ID/

Comments:

Item Name M304B0.500X1.500 Replacement Mfg/ Item ID Purch Purchased

Primary Item Location No

Last Route Seq ID Location 100

Unit of Measure Hand f

Qty on 26.8000

Remaining **Qty To Pick** 0.3160

Date Issued

Status

Page 1

304 BAR .500 x 1.50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT53 26.8 113762 26.8

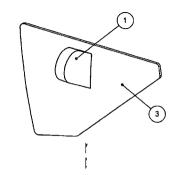
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DATE	STEP	Description of NC Corrective Action Sec					Verific	Verification Appro		Approval
	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector	
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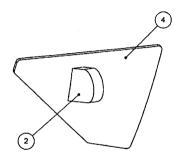
DART AEROSPACE LTD	Work Order: 58074
Description: Lug	Part Number: DH049-1
Inspection Dwg: Rev: A	Page 1 of 1

	FIRST	ARTICLE IN	SPECTIO	ON CHE	CKLIST		
	X	First Artic	le	Proto	type		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method Inspection		mments
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210.8	+130	110.8		···			
1.84	+/030	1.83					
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109	1/- 1/20	109"				_	
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Measured by:		Audited by:	08		Prototype	Approval:	N/A
Date:	10.5.7		2/00/		,	Date:	N/A
L		Date.	05/05/0	الــــ			
Rev Date	Change					Revised by KJ/JLM	Approved

			_	,
ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D4049-041	MOUNTING LUG ASSY, LH
		Х	D4049-042	MOUNTING LUG ASSY, RH
1	. 1		D4049-1	LUG
2		1	D4049-2	LUG
3	1		D4049-3	MOUNTING PLATE, LH
4		1	D4049-4	MOUNTING PLATE RH



D4049-041 MOUNTING LUG ASSY, LH



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SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT

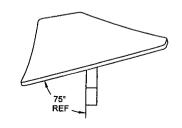
WITHOUT NOTICE WORK ORDER

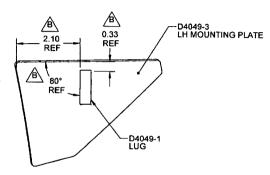
D4049-042 MOUNTING LUG ASSY, RH

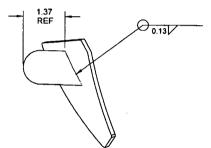


В	80 ° WAS	83°, 0.33 WA	S 0.55 & 2.10 WAS 2.50 (ZN C6-2)	RF	10.03.19			
Α	NEW ISS	SUE		RF	10.01.29			
REV.			DESCRIPTION	BY	DATE			
DESIG	N	RF	DART AEROSP	ACE	TD			
DRAWN RF,			HAWKESBURY, ONTARIO, CANADA					
CHECKED -#		-#	DRAWING NO.		REV. B			
MFG. A	PPR.	_ <i>K</i>	D4049		SHEET 1 OF 7			
APPRO	VED	#	TITLE		SCALE			
DE APPR.			MOUNTING LUG ASS	NTS				
DATE	10.0	3.19	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLED ON THE EVINESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPED OR COMMANICATED TO ANY OTHER PERSON WITHOUT					

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Wlo 38074.

8 D4049-041 MOUNTING LUG ASSY, LH

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NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.64 ibs
8) WELD PER DART QSI 004 USING WELDING JIG DT9584

DESIGN	RF	DART AEROSPACE LTD						
DRAWN	RF		HAWKESBURY, ONTARIO, CANADA					
CHECKED	-44	DRAWING NO.	REV. B					
MFG. APPR.	77	D4049	SHEET 2 OF 7					
APPROVED	-#	TITLE	SCALE					
DE APPR.	-#	MOUNTING LUG ASSY	NTS					
DATE 10.03	3.19	COPYRIGHT © 2010 BY DART AEROSPACE LTD THE DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS						

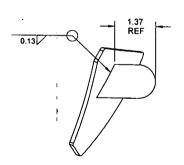
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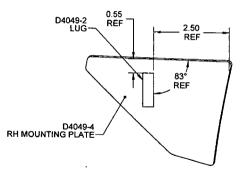
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DATE	STED	Description of NC	Corrective Action Section B				Verific	ation	Approval Chief Eng	Approval	
- DAIL	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Section C		QC Inspector			
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8 D4049-042 MOUNTING LUG ASSY, RH



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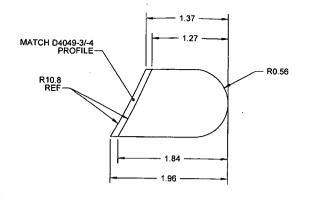
NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-042" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.64 lbs
8) WELD PER DART QSI 004 USING WELDING JIG DT9583

DESIGN RF		DART AEROSPACE LTD						
DRAWN	RF		HAWKESBURY, ONTARIO, CANADA					
CHECKED	-##-	DRAWING NO.	REV. B					
MFG. APPR.	N	D4049	SHEET 3 OF 7					
APPROVED	1	TITLE	SCALE					
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DATE	STEP	Description of NC	Corrective Action Section Initial Action Description		tion B	Cian e Ve		ation	Approval Chief Eng	Approval	
		Section A	Chief Eng			Date	Section C			QC Inspector	
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D4049-1 LUG (SHOWN) D4049-2 LUG (OPPOSITE)

WIO 38074

RELEASED
2010-01-11

NOTES:
1) MATERIAL: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.17 lbs

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DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN RF CHECKED DRAWING NO. REV. B D4049 MFG. APPR. SHEET 4 OF 7 TITLE APPROVED SCALE MOUNTING LUG ASSY

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W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Resolution:							ed: Date:					
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR)		***************************************	***************************************			
DATE	STEP Description of NC Section A		Corrective Action Section			Verification		Approval	Approval			
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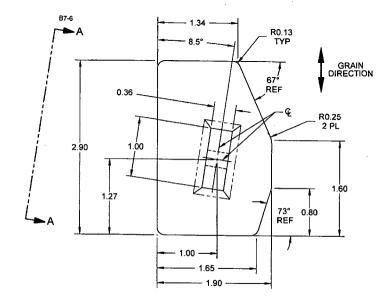
7 5 3 2 →/-- 0.125 REF D Ð 75° REF 0.20 R0.13 TYP D4049-3 MOUNTING PLATE, LH (MAKE FROM D4049-3F FLAT PATTERN) 4.12 0.125 REF 2.90 2.39 - 0.20 REF ∑ R10.7 R0.25 **D4049-3F FLAT PATTERN** w/058074 D4049-4 MOUNTING PLATE, RH (MAKE FROM D4049-3F FLAT PATTERN) NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH, 0.125" THICK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA DESIGN RF DART AEROSPACE LTD 2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE DRAWN RF HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D4049 MFG. APPR. SHEET 5 OF 7 TITLE **APPROVED** SCALE 7) WEIGHT: 0.46 lbs DE APPR. MOUNTING LUG ASSY COPYRIGHT © 2010 BY DART AEROSPACE LTD
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NOT TO BE USED FOR ANY PURPOSE ON COMED ON COMMUNICATED TO MAY OTHER POISSON WITHOUT DATE 10.03.19 8 3

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0.75 0.50 1.00 REF R0.50 Ø0.257 R0.13 ALL AROUND

VIEW A-A D5-6



W1038074

D4049-5 MOUNTING LUG, LH

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AMS-QQ-A-225/8 OR AMS-QQ-A-200/8 OR ASTM B211 OR B221
PER DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-5" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.10 lbs

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DESIGN	RF	DART AEROSPACE LTD						
DRAWN	RF,	HAWKESBURY, ONTARIO, CANADA						
CHECKED	4	DRAWING NO.	REV. B					
MFG. APPR.	77	D4049 si	HEET 6 OF 7					
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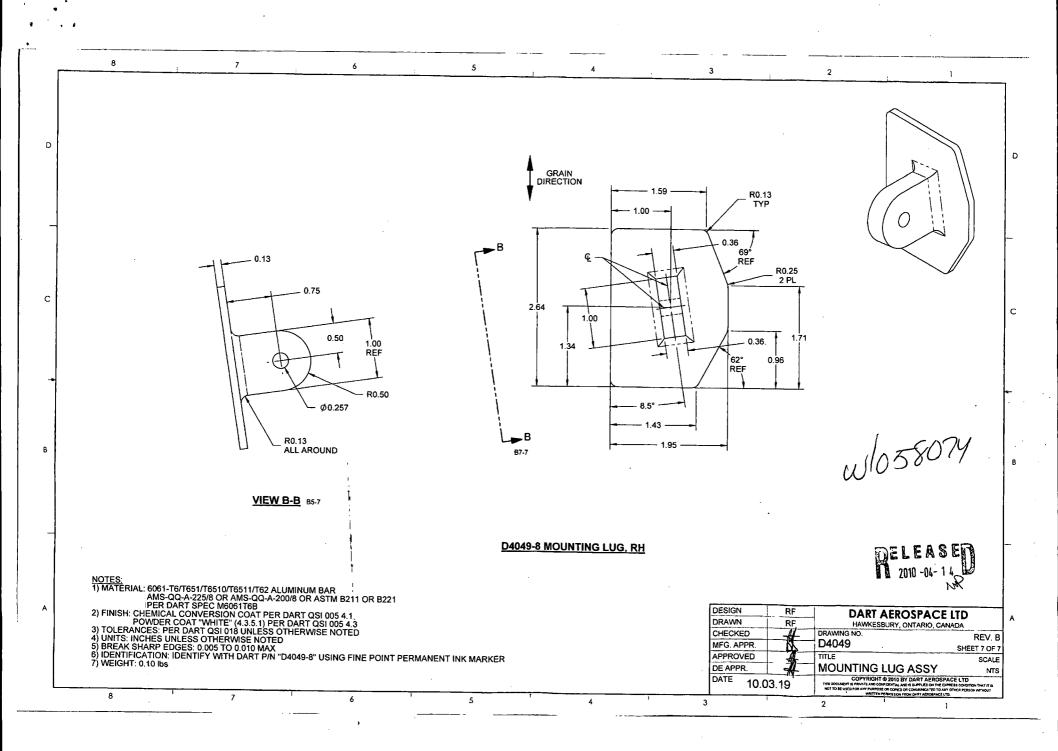
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NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)		
DATE	STEP	Description of NC	Corrective Action Section			Verification	1 Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C	Chief Eng	QC Inspector
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Resolution:										
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DATE	STEP	Description of NC	Corrective Action Secti				Verific	cation Approval	Approval	Approval
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